



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2274 Job Sheet 193166



Part No: D2274

Job Qty: 120 pcs

DAS
21
9-89

Part Name: Radius Block



Part Weight: 0 lbs

Job Created: 4/9/19

Due Date: 6/18/19

Type: Stock

Status: New

Job Tracking No: SIOP

Created By: Dara Macdonald

Description:

Priority: Medium

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Shear - 1	120 pcs	6/18/19	6/18/19	0.00	0.06	Shear - 1		mm L 19/05/18
105	Waterjet - Flow - B4B	120 pcs	6/18/19	6/18/19	0.00	6.00	Waterjet - Flow - B4B		
110	HAAS 4 Axis - B4B	120 pcs	6/18/19	6/18/19	0.01	2.87	HAAS - 1 - B4B		
							HAAS - 2 - B4B		mm L 19/05/18
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	120 pcs	6/18/19	6/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		mm L 19/05/21
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		



Container No: S182327



Part No: D2274

Job No: 193166

Serial No/Batch: S182327

Revision:

Inspector:

Ship Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 05/18/19

				QC 8 - 23	
14G Small Fab - 2 - B4B	120 pcs	6/18/19	0.00 0.65	Small Fab - 1 - B4B	JRB
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 Handfinish - 1-1 Chemical-B4B	120 pcs	6/18/19	0.00 0.31	Handfinish - 1 - 1 - B4B	JUN 06 2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	120 pcs	6/18/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	

					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
170	Packaging 3-1 - Stock - B4B	120 pcs	6/18/19	0.00 0.00	Packaging 3 - 1 - B4B	JUN 07 2019 40 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	JUN 07 2019
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	120 pcs	6/18/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59

JUN 07 2019

Part Op 100 - (Shear) blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
 Descriptions: 105 - (Waterjet - Flow) CUT BLANK blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
 110 - (HAAS CNC vertical machine #1) Machine as per folio D2274
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) Tumble Deburr any rough edges after tumbling
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	9.9600 ft (.083 ea)	100-Shear - 1	S166897
M6061T6S.125	6061-T6 .125 Sheet	.7200 sf (.006 ea)	105-Waterjet - Flow - B4B	

MAT
used
22 329

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Shear - 1	M6061T6B0.750X00.125	10	145	0
105-Waterjet - Flow - B4B	M6061T6S.125	1	90	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		